Work Order ID 97353 Friday, February 15, 2013 2:58:42 PM				*97353*								Page 1
Revision ID:	03876-13 rotector - Do	or		Accept	*N90	) ) ) ) )	1100	)*		tart top	*N.	S1* S2*
Start Date: 2. Required Date: 2. Reference:	/15/2013 /22/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Ito						I VI	
	Process Pla	n: UUC	Date: (3-2-9)	Tooling: SPC (Y/N):		Date:				tart top	*N *N	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool I	ID Tool#	Plan Code	Accep Qty	t Reject Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3876	Α											
*100 *100* Waterjet		FLOW WATER JET Memo		0.00				B				Jm 13-2-20
FLOW CNC Waterjet			A									
*110 *110*		QC2- Inspect parts off r	nachine FAI/FAIB	0.00				7	· 6			7
QC Quality Control		Memo		0.00					<u> </u>			Jm13-2-20
120 *120*		QC8- Inspect parts - sec	cond check	0.00 SW	)			7				
QC Quality Control		Memo		0.00 13-7	<b>D</b>			- <del>J</del>				

NCR:	Yes	/ No				WORK ORDER NON-C	100	VFOR	MANCE / UP	DATE		_		
											QA Closed	: Date:	· · · · · · · · · · · · · · · · · · ·	
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No.  NCR No.						Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Crosstube Small Fab Finishing Composite	Pr Rec/Sto	Engineering Quality Other			
Root					Descri	ption of work order update		nitial	Ac	ction	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						F	AUI	T CATE	GORY					
Landi	ng G	iear				General	_	1		_	_	F	1	
	$\vdash$	Bending	nt Concer	ntric to	0/5	Bend BOM/Route	-	Grain	ıre	-	Ovalized	r tolerance	Pressure/Forced Temperature/Cure	

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 97353 \*97353\* Friday, February 15, 2013 2:58:42 PM Item ID: D3876-13 Accept \*N900040100\* Setup Start **Revision ID:** Stop Item Name: Protector - Door **Start Date:** 2/15/2013 Start Qty: 6.00 **Cust Item ID:** Required Date: 2/22/2013 **Req'd Qty:** 6.00 **Customer:** Reference: Run Start Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 Identify as per dwg & Stock Location:\_ 0.00 \*130\* Packaging 0.00 Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

QC

\*140\*

Quality Control

Insp.

Page 2

13-2-22

											DQA:	Date:	
NCR:	Yes /	' No				WORK ORDER NON-C	O	VFOR	MANCE / UPDATE				
			-		÷	Υ	_		-		QA Closed:	Date	
Morle Orde	~					DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS	
Work Orde	er				*******	Rework	1		Skid-tube Crosstub			Water Jet	Engineering
Part N	Nο					Scrap	1 1		Machining Small Fa	-	Prod	d. Eng. Coor.	Quality
rurei	•••		<del> </del>			Use-as-is			noforming Finishin			e/Packaging	Other
NCR I	No.					Work Order Update			Large Fab Composit	~	,	Supplier	1
i	_					· L							
Root					Descri	ption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data										1			
Equip/Tooling										ļ			
Operator	Ш						į			,			
Material													
Setup	$\square$												
Other	Н												
Process	Ы			·									
Supplier	Н												
Training	Н												
Unapproved	<u> </u>		/	L			<u> </u>	T CATE	GORV		<u> </u>		<u> </u>
Landi	ng Ga	ar .				General	AUI	. CATE	dokt				
Land		ending				Bend		Grain			Ovalized	Г	Pressure/Forced
	$\vdash$	_	t Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	${f}$	racks				Broken/Damaged	_	4	ion Incomplete	-	Part Incorred	<b>)</b>	Weld
	${f oxdot}$		Crimped.		<u> </u>	Burrs		4 '	tions Incomplete/Unclear		Part Lost/Mi	<u> </u>	Wrong Stock Pulled
	<del></del>	uffs	•			Contamination		Mainte	'		Part Moved		
	Πн	eat Trea	t			Countersink	Г	Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

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## **Picklist Print**

Friday, February 15, 2013 2:58:42 PM

Work Order ID:

97353

Parent Item:

D3876-13

Parent Item Name:

Protector - Door

**Start Date: 2/15/2013** 

Required Date: 2/22/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09.01.23 new issue EC verifyed by:DD

				J J									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04	· · · · ·	Purchased	No			100	sf	0.0000	3.19	19.14			
GE PLASTICS LEXAN SH	EET									20		Alleren Wile conflic	JMB-2-20

124655

124655

												DQA:	Da	te:	•
NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORN	ANCE / UP	DATE		_			
											Q	A Closed:	Da	te:	
Work Ord	۵r۰					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	٠, .					Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part I	No.					Scrap		N	Machining	Small Fab		Prod	d. Eng. Coor.		Quality
						Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging	_	Other
NCR I	۷o.				<del></del>	Work Order Update	╛╏		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		nitial	Ac	tion	T	Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription		Date	Verificatio	n	QC inspector
Doc/Data			•				†		· · · · · · · · · · · · · · · · · · ·	·	1				
Equip/Tooling															
Operator															
Material												1			
Setup											1				
Other															
Process															
Supplier								1							Į
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (	Gear				General				_	_				3
	<u> </u>	Bending				Bend		Grain		<u></u>	_lc	Ovalized		<u> </u>	Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Jc	ver/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		P	art Incorrec	ct .		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	\tiny  P	art Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		_ P	art Moved			
		Heat Trea	it			Countersink		Mislabe	led		J₽	ositioned <b>V</b>	Vrong		-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		P	ower Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	97353
Description: Protector - Door	Part Number:	D3876-13
Inspection Dwg: D3876 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.25	+/-0.030	27.25"	-		T	Jkm 06
17.43	+/-0.030	17.434	_		7	
1.50	+/-0.030	1.50"	_		V	Jkmo1
0.67	+/-0.030	0.67"	_		V	
6.84	+/-0.030	6.84"			V	
9.59	+/-0.030	9.59"	-		V	Productor
16.75	+/-0.030	16.75"	-		4	
0.125	+/-0.010	0.126"	_		V	
L			040	·		

Measured by:	Im	Audited by:	15	Prototype Approval:	N/A
Date:	13-2-20	Date:	13231	Date:	N/A

Rev	Date	Change	Rev	ised	by	Approved
_A	09.06.22	New Issue	KJ	- GJ		111
				7	7	

